

Work Order ID: 56859

March 11, 2010 10:10:46 AM



Page 1

Item ID: D119-646-143

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Date: 3/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/19/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3905

B

D3905-043,-11

B

IIN-D119-646

B

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D119-646-143  
CHG 001

N/A

110

0.00



Skidtubes

Skidtubes

Memo

0.00

1- Inspect Mat'l D2500-1-190 for damage

2- Ensure squareness of ends

Handwritten signature

10-3-16

**Work Order ID 56859**

Page 2

March 11, 2010 10:10:47 AM

Item ID: D119-646-143

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube w/ Full Length Wearplates &amp; Wearpads

Start Date: 3/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/19/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

Chemical Conversion Coat per QSI005 4.1

0.00

DP

10-3-16



HandFinish

Memo

0.00

Hand Finishing

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 10/3/16

150

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Install drill jig DT9480 drill all x-bolt spacer holes using 3/16 drill

2- Scribe batch # inside aft end of tube

DP

10-3-16

# Work Order ID 56859



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March 11, 2010. 10:10:51 AM

Item ID: D119-646-143

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Date: 3/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/19/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

155

0.00



CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1- Bend AFT end of tube using CNC Bender 1 and bend prog. D3905 AFT as per dwg D3905. Must use bending Aid DT9538, located 23.25" from Aft end.

2- Esure bending Aid DT9538 is positioned correctly, that the bender set up in on full wide and that the indexing ridge is covered with graphite grease.

> DP 10-3-17

165

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

h2 5.250" 8/16/17

(10)

# Work Order ID 56859



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March 11, 2010 10:10:52 AM

Item ID: D119-646-143

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Date: 3/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/19/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Verify dimention of bend as per dwg D3905

2- Buff out marks left from bending.

3- Drill Aft Float bag holes using DT9493 as per dwg D3905 detail G and section F-F open to finished size

4- Drill Aft wearplate and wearpad holes using DT9546 and DT9545 as per dwg D3905 detail H open to finished size

5- Open x-bolt spacer holes to finished size as per dwg (sections D-D and E-E)

\*\*\*DO NOT OPEN FWD SADDLE HOLES\*\*\*

6- ~~Drill wearplate holes using DT~~

7- Deburr, blow out chips from inside of tube

8- Bond web in place as per Dwg D3905 & OSI 015.

A/R ☐ Sikaflex-291 ☐ M112-429 ☐

Sikaflex expire date: 10-8-30

Start: ☐

Time: ☐ 11:30 AM

Finish: ☐ 10/04/05 ☐

Time: ☐ 7:45 AM

\*\*\*\*\* (Adhere for 12 hours) \*\*\*\*\*

spot face float fwd, Top Facing wearplate holes to 0.5625 to accommodate insert (1 per side)

open to finished size as per dwg D3905

DP 10-3-31

10.03.17

**Work Order ID 56859**

Page 5

March 11, 2010-10:10:57 AM

Item ID: D119-646-143

Accept



.Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube w/ Full Length Wearplates &amp; Wearpads

Start Date: 3/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/19/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

200



CNC Bend I

CNC Delta 100 Bender

0.00

0.00

Memo

1- Bend Fwd end of tube using bender I and bend prog. D3905 Fwd.Use bending aid DT9544 ensure proper positioning

2- Cut Fwd end of tube as per dwg.

\*\*\*VERIFY MEASUREMENT BEFORE CUTTING\*\*\*

DP 10-4-5

DP 10-4-6

PTO

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D119-646-143 PAR #: \_\_\_\_\_ Fault Category: skid holes NCR: Yes No DQA: \_\_\_\_\_ Date: 10/05/20  
 Resolution: accepted Disposition: use as is QA: N/C Closed: \_\_\_\_\_ Date: 10/05/20

NCR: <u>5685A</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.04.06	200	FRONT IS OVERBENT. HEIGHT IS 5.4" @ 178.5 TOTAL LENGTH. TOTAL LENGTH IS UNDER TOL. BY 0.5"	<u>CP</u> 10.04.06 PC QSI 042	Acceptable.	<u>LD</u> 10-4-5	<u>S</u> 10/04/19	<u>CP</u> 10.04.06 PC QSI 042	<u>S</u> 10/04/19
		R.C. Machine Slippage/process						

NOTE: Date & initial all entries

# Work Order ID 56859

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Item ID: D119-646-143

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Date: 3/11/10 Start Qty: 1.00

Cust Item ID:

Required Date: 3/19/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Buff out marks left from bending

2- Drill Fwd cap holes using DT8215. Open Fwd and Aft cap holes to 0.208"

3- Open Fwd saddle holes to finished size as per dwg

4- Drill Fwd x-bolt hole and open to finished size. (Holes must be laid out manually)

5- Drill towing hole and open to finished size. (Holes must be laid out manually)

6- Open Aft float holes 0.391" as per dwg D3905 detail G and section F-F

8- Deburr, blow out chips from inside of tube.

W 10/4/19

NIA

Drill wearplate holes using DT 9613  
as per dwg D3905-043

220

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/4/19



# Work Order ID 56859

March 11, 2010 10:11:03 AM



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Item ID: D119-646-143

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Date: 3/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/19/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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224

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Countersink x-bolt holes as per dwg

2- Remove alodine prepare for welding

3- Insert x-bolt spacers

4- Weld x-bolt spacer as per dwg  
A/R Alum rod Batch: m112860

5- Grind welds flush as per dwg

6- Counter bore x-bolt holes as per dwg

7- Deburr

*BE 10/05/03*

225

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*S. Wlosky*

*Ⓢ*



# Work Order ID 56859



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March 11, 2010 10:11:03 AM

Item ID: D119-646-143

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Date: 3/11/10

Start Qty: 1.00



Cust Item ID:

Required Date: 3/19/10

Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

226

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

*Sidlosky*

*Ⓢ*

Quality Control

227

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

*RE-ALIGNED (PAR 04043).*

*① 10-5-5.*

Hand Finishing

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

*M114207 START: 11:30am*

*7/26/ 10/05/05*

*21*

*⌀*

Powder Coating

*Temp: 320°*

*FIN: 12:00pm*

# Work Order ID 56859

March 11, 2010 10:11:08 AM



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Item ID: D119-646-143

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Date: 3/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/19/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

245

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

= 7m, k w/05/05 (1K)

250

Memo

0.00



HandFinish

Hand Finishing

1-Install inserts as per Dwg D3905.

0.00

= 7m, k w/05/05 (1K)

260

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

n/k

# Work Order ID 56859

March 11, 2010 10:11:09 AM



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Item ID: D119-646-143 Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Date: 3/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/19/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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270

0.00



HandFinish

Hand Finishing

Memo

0.00

1-Install wearpads, gaskets and wearplates as per Dwg D3905. Put sikaflex in insert before installing bolts and washers

A/R ☐ Sikaflex-240/-291 ☐ M112429

Sikaflex expire date: ☐ 10/08

2- install plugs assembly as per dwg. O-Ring Lub Batch: M114189

3 -Inspect for foreign objects as per QSI 024

4 -Install Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R ☐ Sikaflex-240/-291 ☐ M112429

Sikaflex expire date: ☐ 10/08

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

QC

Quality Control



280

S10606

M-1 10/05/05  
Pat

# Work Order ID 56859

March 11, 2010 10:11:14 AM



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Item ID: D119-646-143

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Date: 3/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/19/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

285 280 5



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch M113545

Memo

0.00

7m-1 12/05/05



286 281 5



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

5/10/06

XL

290



Packaging

Packaging

Identify as per dwg & Stock Location:

Memo

0.00

0.00

PAP 56736

Per 10/19 @

**Work Order ID 56859**

March 11, 2010 10:11:14 AM



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Item ID: D119-646-143

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube w/ Full Length Wearplates &amp; Wearpads

Start Date: 3/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/19/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/19 *[Signature]*  
MF  
10-5-19

# Picklist Print

March 11, 2010 10:10:29 AM

Page 1

Work Order ID: 56859

Parent Item: D119-646-143

Parent Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Date: 3/11/10

Required Date: 3/19/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2500-1-190



Ext'n -1' Beam Tube 4"

Manufactured

No

110

Each

75.0000

1.0000



## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

LG

72

52319

72

Main Warehouse

ST

3

46468

3

D3885-3



Standard Web

Manufactured

No

170

Each

12.0000

1.0000



## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

12

51844

1

52425

11

D3903-1



Spacer

Manufactured

No

190

Each

40.0000

12.0000



## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST095

40

47476

10

51849

30

10-3-17

10-3-31

12

BE 10/05/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March 11, 2010 10:10:30 AM

Work Order ID: 56859



Parent Item: D119-646-143



Parent Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Date: 3/11/10

Required Date: 3/19/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3681-1 Spacer		Manufactured	No			190	Each	9.0000	8.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

7

51920

5

52898

2

Main Warehouse

ST

2

47123

2

D3683-3

Purchased

No

250

Each

599.0000

12.0000



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST078

599

47805

599



12x m-l  
6/05/05

March 11, 2010 10:10:30 AM

Shop Packet Print



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March 11, 2010 10:10:30 AM

Work Order ID: 56859

Parent Item: D119-646-143

Parent Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Date: 3/11/10

Required Date: 3/19/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			250	Each	834.0000	42.0000			
Insert												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse	M 114407	
ST282	834	
110511	834	

42 x m-l  
10/05/05

D2855-3		Manufactured	No			270	Each	11.0000	2.0000			
Cap												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
fp5	11	
52281 ✓	11	

2 x m-l 10/05/05

D3672-1		Manufactured	No			270	Each	1,610.000	4.0000			
Phenolic Washer												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST077	1610	
39275	19	
42329	5	
47628 ✓	86	
51674 ✓	500	
52505	1000	

4 x m-l 10/05/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March 11, 2010 10:10:30 AM

Work Order ID: 56859



Parent Item: D119-646-143



Parent Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Date: 3/11/10

Required Date: 3/19/10

Comments: IPP ReVA: New issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3846-1		Manufactured	No			270	Each	49.0000	1.0000			
GASKET												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST236B

49

47806

11

51827 ✓

6

53735

32

D3846-11		Manufactured	No			270	Each	27.0000	1.0000			
GASKET												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

FP

16

51833 ✓

16

Main Warehouse

ST

11

47807

11

10/05/05

1x m-l

10/05/06

1x m-l

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March 11, 2010 10:10:31 AM

Work Order ID: 56859



Parent Item: D119-646-143



Parent Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Date: 3/11/10

Required Date: 3/19/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3847-1		Manufactured	No			270	Each	35.0000	8.0000			
WEARPAD												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

35

47808

4

51823 ✓

31

D3847-11

Manufactured No

270

Each

17.0000

1.0000



WEARPAD

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

15

51824 ✓

15

Main Warehouse

ST

2

47809

2

*Bx m-l 10/05/05*

*1X m-l 10/05/05*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March 11, 2010 10:10:31 AM

Work Order ID: 56859



Parent Item: D119-646-143



Parent Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads


Start Date: 3/11/10

Required Date: 3/19/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3672-3  Phenolic Washer		Manufactured	No			270	Each	492.0000	12.0000			

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST077

492

51596

1

55560 ✓

491

AN3C5A

Purchased

No

270

Each

541.0000

46.0000



Bolt



Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST351

541

111424

8

111707

69

112314

1

113121

37

113149

126

114056

200

114108

100

M 114330

12x m-l 10/05/05

46x m-l 10/05/05



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March 11, 2010 10:10:32 AM

Work Order ID: 56859

Parent Item: D119-646-143

Parent Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Date: 3/11/10

Required Date: 3/19/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN960C10L		Purchased	No			270	Each	388.0000	46.0000			
-----------	--	-----------	----	--	--	-----	------	----------	---------	--	--	--



washer

NAS1149C0332R

M114341

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

288

112116

128

112612

160

46x m-1  
b/o 5/05

AN960C416

Purchased

No

270

Each

473.0000

12.0000



washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST346

473

100993 ✓

473

12x m-1  
b/o 5/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March 11, 2010 10:10:33 AM

Work Order ID: 56859



Parent Item: D119-646-143



Parent Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Date: 3/11/10

Required Date: 3/19/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039C4-08		Purchased	No			270	Each	69.0000	12.0000			
SCREW												

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST293

69

17831

69

D3492-045

Manufactured No

270

Each

74.0000

16.0000



Plug Assembly

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST

74

51638

74

NAS1611-005

O-Ring

Batch: M106099

10.05.05

10/05/05  
12x m-l  
16x m-l  
10/05/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March 11, 2010 10:10:40 AM

Work Order ID: 56859



Parent Item: D119-646-143



Parent Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Date: 3/11/10

Required Date: 3/19/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3847-043		Manufactured	No			270	Each	10.0000	1.0000			
-----------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



FWD WEARPLATE ASSY, STD/ FLOAT GEAR

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

FP	4	
----	---	--

52533	4	
-------	---	--

Main Warehouse

ST179	6	
-------	---	--

48180	1	
-------	---	--

51820	5	
-------	---	--

D3847-045		Manufactured	No			270	Each	11.0000	1.0000			
-----------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



CENTER WEARPLATE ASSY, STD/FLOAT

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST179	11	
-------	----	--

48181	1	
-------	---	--

51821	6	
-------	---	--

52534	4	
-------	---	--

1x m-h 10/05/05

1x m-h 10/05/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 10

March 11, 2010 10:10:40 AM

Work Order ID: 56859



Parent Item: D119-646-143



Parent Item Name: Replacement Float Skidtube w/ Full Length Wearplates & Wearpads

Start Date: 3/11/10

Required Date: 3/19/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3847-049		Manufactured	No			270	Each	6.0000	1.0000			

AFT WEARPLATE ASSY, FLOAT GEAR

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST179	6	
51822 ✓	6	

12 m-1  
10/05/05

March 11, 2010 10:10:41 AM

Shop Packet Print

Page 10



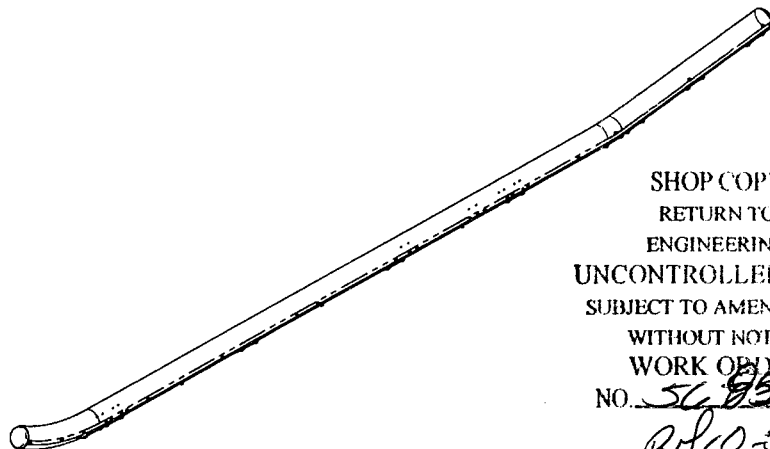
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *56839 U*  
*BS103-05*

**D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)**  
**D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)**  
**D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)**

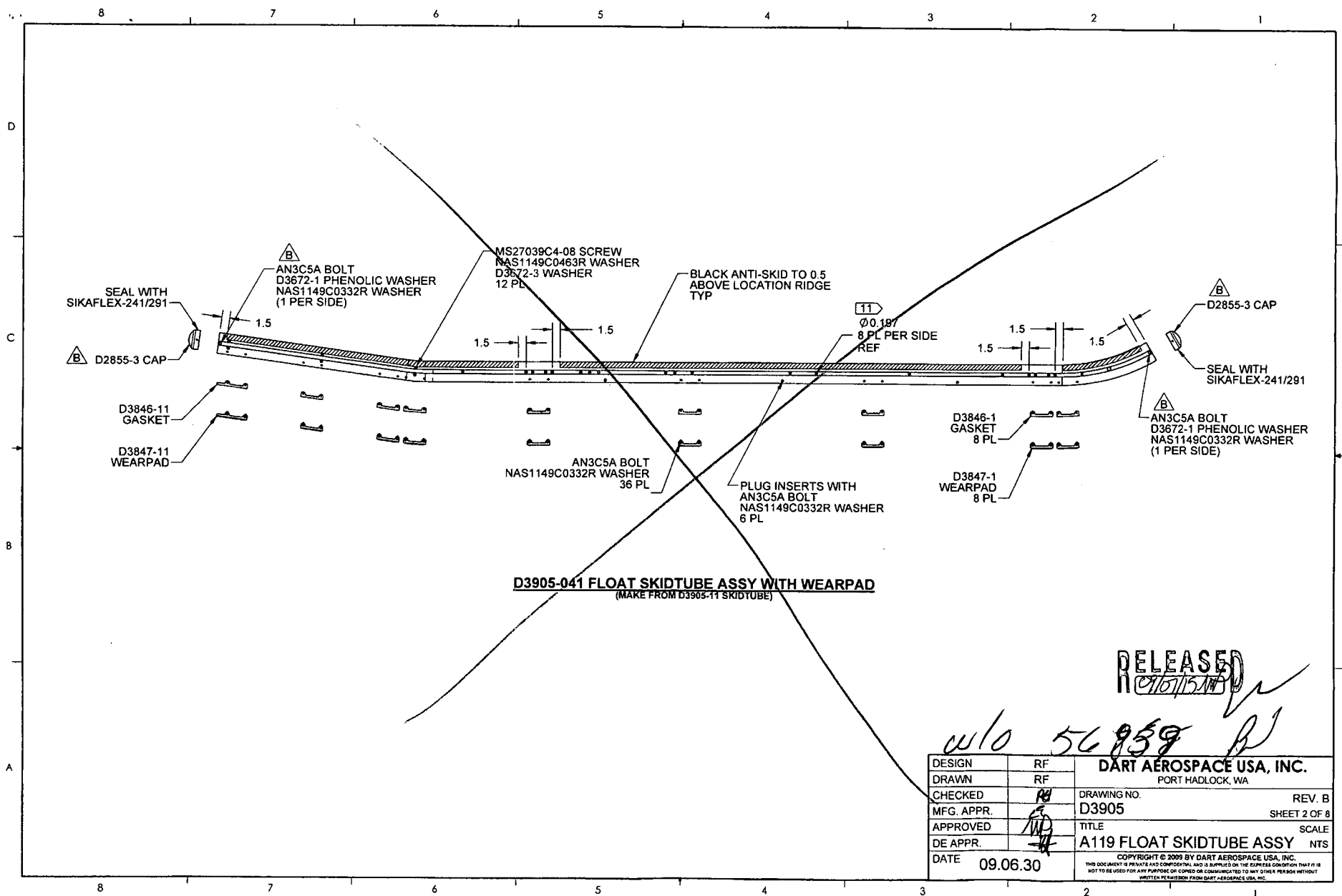
**NOTES:**

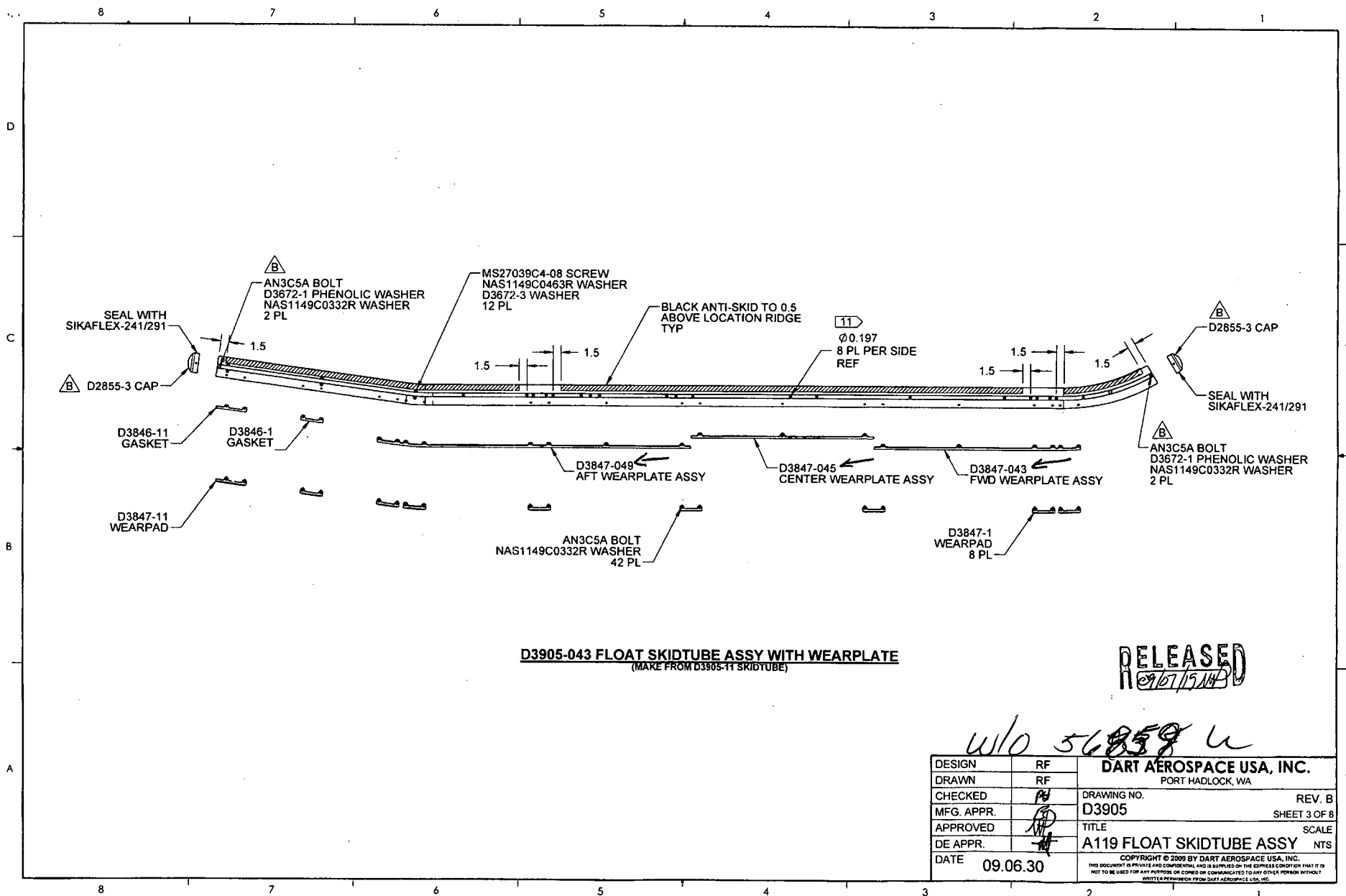
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3885-3 FLOAT WEB  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3905-041 = 40.7 lbs  
D3905-043 = 47.0 lbs  
D3905-045 = 47.3 lbs
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES  
ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT  
PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT  
PORTION OF THE TUBE.
- 10) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE  
WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP
- 11) INSERT D3492-045 PLUG ASSY INTO  $\phi 0.197$  HOLES (BOTH SIDES OF TUBE)
- 12) USE DART DRILL TEMPLATE DT8932 TO LOCATE AND DRILL  $\phi 0.297$  HOLES FOR WEARPLATE INSERTS.  
INSTALL AELS-1032-130 INTO D3905-11 ONLY. INSTALL AN3C5A BOLTS AND NAS1149C0332R WASHERS  
WITH SIKAFLEX-241/-291.

ITEM	QTY -041	QTY -043	QTY -045	P/N	DESCRIPTION
1	X			D3905-041	FLOAT SKIDTUBE ASSY WITH WEARPAD
2		X		D3905-043	FLOAT SKIDTUBE ASSY WITH WEARPLATE
3			X	D3905-045	FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE
11	2	2	2	D2855-3	CAP
12	16	16		D3492-045	PLUG ASSY
13	4	4	4	D3672-1	PHENOLIC WASHER
14	8	8	8	D3681-1	SPACER
15	8	1	1	D3846-1	GASKET
16	1	1	1	D3846-11	GASKET
17	8	8	1	D3847-1	WEARPAD
18	1	1	1	D3847-11	WEARPAD
19		1		D3847-043	FWD WEARPLATE ASSY
20		1		D3847-045	CENTER WEARPLATE ASSY
21		1		D3847-049	AFT WEARPLATE ASSY
22			1	D3849-047	FWD WEARPLATE ASSY
23			1	D3849-045	AFT WEARPLATE ASSY
24	1	1	1	D3885-3	FLOAT WEB
25	1	1		D3905-11	FLOAT SKIDTUBE
26			1	D3905-13	FLOAT SKIDTUBE
27	12	12	12	D3903-1	SPACER
28			16	D3904-1	WASHER
29	12	12	12	D3672-3	WASHER
30	12	12	12	D3683-3	INSERT
31			16	D3411-3	WASHER
41	42	42	10	ALS4-1032-130	INSERT
42	46	46	14	AN3C5A	BOLT
43			4	AN3C46A	BOLT
44			4	AN3C50A	BOLT
45	46	46	10	NAS1149C0332R	WASHER (OR AN960C10L)
46	12	12	12	NAS1149C0463R	WASHER (OR AN960C416)
47			8	MS21043-3	NUT
48	12	12	12	MS27039C4-08	SCREW

RELEASED  
*09/15/2009*

B	REVISED PART LIST. ALS4-1032-130 WAS AELS-1032-130 (ZN A6-5, A5-6, C5-7, C3-7, A5-7); ADD DT8932 (ZN A8-1); D2855-3 WAS D2575 (ZN C8-2, C1-2, C8-3, C1-3, C8-4, C1-4); AN3C5A WAS AN3C4A (ZN C7-2, C1-2, C7-3, C1-3, C7-4, C1-4); D3849-047 WAS D3849-041 (ZN B3-4); ADD D3411-3 (ZN B3-4); ADD AN3C50A (ZN B3-4); $\phi 0.313$ WAS $\phi 0.328$ (B2-5, B2-6, C2-7, A8-7 & D7-8); REVISED NOTE iv (ZN A8-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3905	SHEET 1 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	





SEAL WITH  
SIKAFLEX-241/291

D2855-3 CAP

D3846-11 GASKET

D3847-11  
WEARPAD

AN3C5A BOLT  
NAS1149C0332R WASHER  
10 PL

AN3C5A BOLT  
D3672-1 PHENOLIC WASHER  
NAS1149C0332R WASHER  
(1 PER SIDE)

D3846-1  
GASKET

D3847-1  
WEARPAD

MS27039C4-08 SCREW  
NAS1149C0463R WASHER  
D3672-3 WASHER  
12 PL

AN3C46A BOLT  
D3904-1 WASHER, 2 PL  
MS21043-3 NUT  
4 PL

D3849-045  
AFT TRAINING WEARPLATE ASSY

BLACK ANTI-SKID TO 0.5  
ABOVE LOCATION RIDGE  
TYP

AN3C50A BOLT  
D3904-1 WASHER, 2 PL  
D3411-3 WASHER, 4 PL  
MS21043-3 NUT  
4 PL

D3849-047  
FWD TRAINING WEARPLATE ASSY

D2855-3 CAP

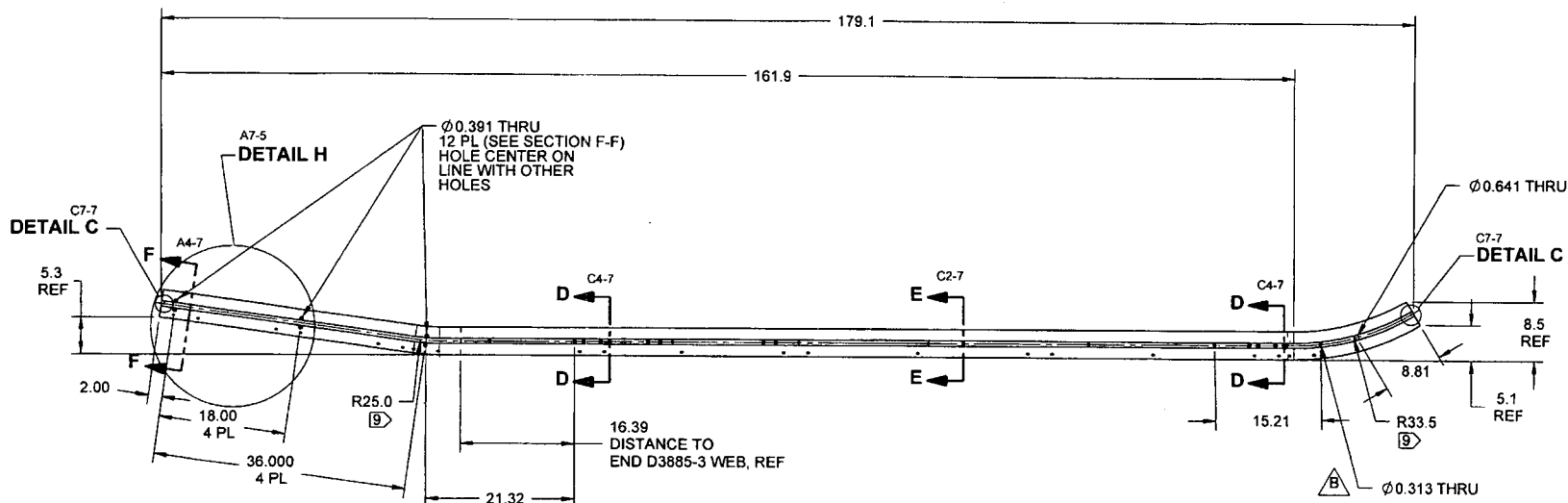
SEAL WITH  
SIKAFLEX-241/291

AN3C5A BOLT  
D3672-1 PHENOLIC WASHER  
NAS1149C0332R WASHER  
2 PL

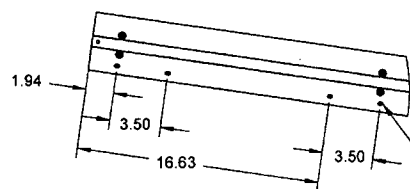
**D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE**  
(MAKE FROM D3905-13 SKIDTUBE)

RELEASED  
09/07/15 M4

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3905	SHEET 4 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 FLOAT SKIDTUBE ASSY	NTS
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**D3905-11 FLOAT SKIDTUBE**  
(MAKE FROM D3905-1 TUBE)



**DETAIL H**  
SCALE 2X C7-5

DRILL  $\phi 0.297$   
INSTALL ALS4-1032-130 INSERT  
AFTER FINISH, SEE SECTION F-F  
TYP, 2 PL

RELEASED  
09/07/15

DESIGN	RF	DART AEROSPACE USA, INC.	
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CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3905	SHEET 5 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 FLOAT SKIDTUBE ASSY	NTS
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DETAIL G

DETAIL C

5.3  
REF

2.00

18.00  
4 PL

R25.0

36.00  
4 PL

Ø0.391 THRU  
12 PL (SEE SECTION F-F)  
HOLE CENTER ON  
LINE WITH OTHER  
HOLES

C4-7

D

16.39  
DISTANCE TO  
END D3885-3 WEB, REF

21.32

C2-7

E

C4-7

D

15.21

Ø0.641 THRU

DETAIL C

8.5  
REF

8.81

5.1  
REF

R33.5

9

Ø0.313 THRU

D3905-13 FLOAT SKIDTUBE  
(MAKE FROM D3905-1 TUBE)

1.94

3.50

14.70

3.50

32.89

B

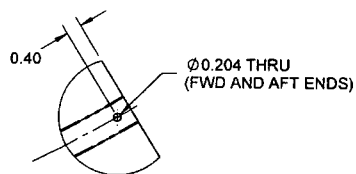
DRILL Ø0.297  
INSTALL ALS4-1032-130 INSERT  
AFTER FINISH, SEE SECTION F-F  
TYP, 2 PL

DETAIL G  
SCALE 2X

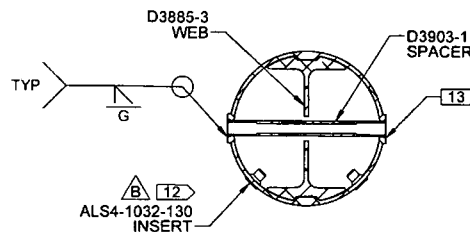
C8-6

RELEASED  
29/07/15

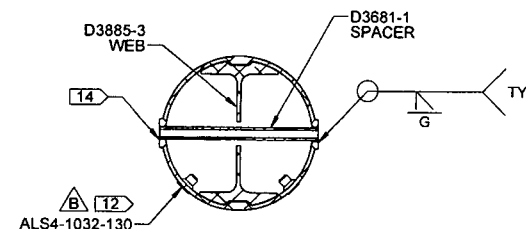
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3905	SHEET 6 OF 8
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	A119 FLOAT SKIDTUBE ASSY	NTS
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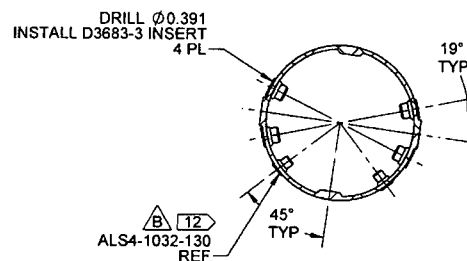
**DETAIL C**  
SCALE 4X  
C1-5  
C8-5  
C8-6  
C1-6



**SECTION D-D**  
SCALE 4X  
C5-5  
C2-5  
C5-6  
C2-6  
(FOR 12 x  $\phi 0.375$  HOLES  
PER SKIDTUBE)



**SECTION E-E**  
SCALE 4X  
C4-5  
C4-6  
(FOR 8 x  $\phi 0.313$  HOLES  
PER SKIDTUBE)



**SECTION F-F**  
SCALE 4X  
C7-6  
C7-5

**NOTES:**

13) AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR  $\phi 0.375$  HOLES ONLY:

- CHAMFER HOLES  $\phi 0.475 \times 45^\circ$  (BOTH SIDES)
- INSERT D3903-1 SPACER
- WELD INTO PLACE AND GRIND FLUSH
- C'BORE TO  $0.313 \times 0.75$  DEEP
- DEBURR HOLES

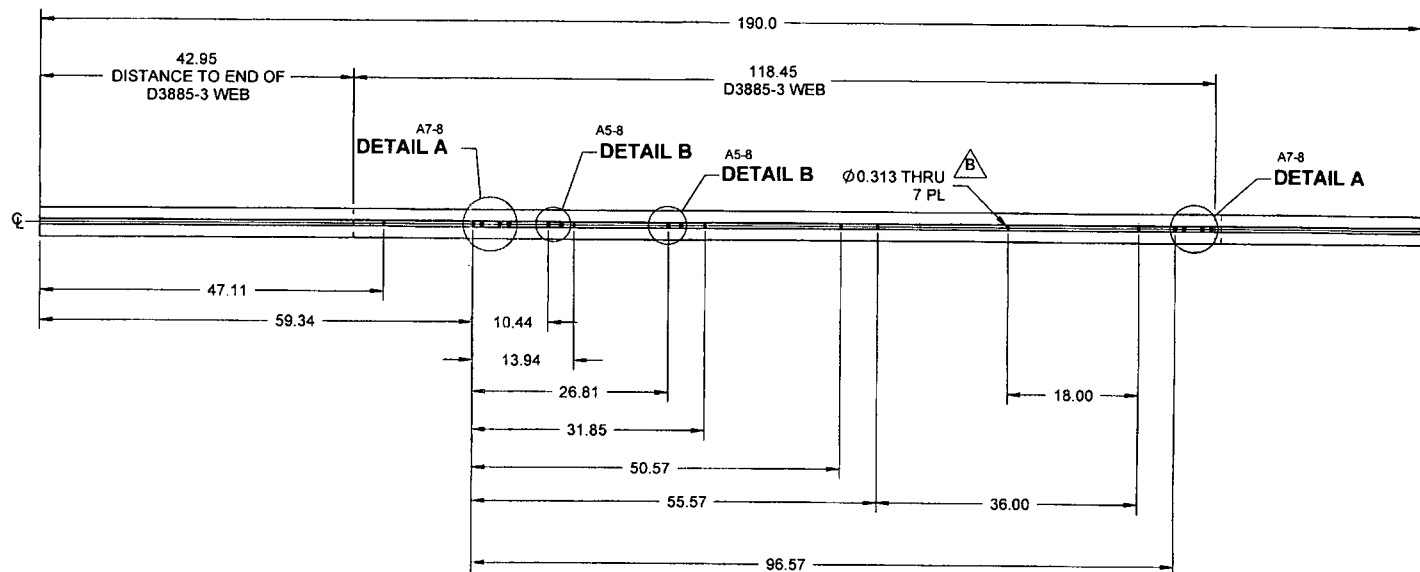
14) AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR  $\phi 0.313$  HOLES ONLY:

- CHAMFER HOLES  $\phi 0.354 \times 45^\circ$  OR  $0.050$  DEEP  $\times 45^\circ$  (BOTH SIDES)
- INSERT D3681-1 SPACER
- WELD INTO PLACE AND GRIND FLUSH
- DEBURR HOLES

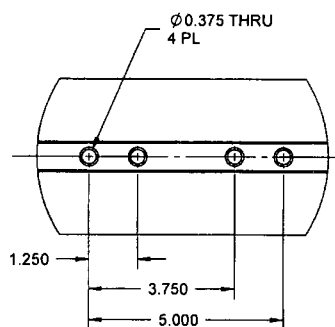
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DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.	RF	D3905	SHEET 7 OF 8
APPROVED	RF	TITLE	SCALE
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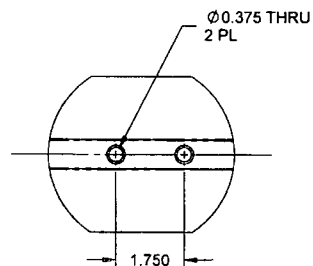




**D3905-1 TUBE**  
(MAKE FROM D2500-1-190 EXTRUSION)



**DETAIL A**  
SCALE 4X  
D6-8  
D2-8



**DETAIL B**  
SCALE 4X  
D5-8  
D4-8

**RELEASED**  
01/07/15/10

*W/O 56 859 W*

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MFG. APPR.	<i>[Signature]</i>	<b>D3905</b>	SHEET 8 OF 8
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NO. 217

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Bardley Elliott  
Job number: 52996  
Part number: D119-646-243  
Description: 119 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Sgt. Dymally Date of Test Coupon 09.11.16

Welder Bardley Elliott Date of Test Coupon 09.11.16

The above named individual is qualified in accordance with AWS D17.1.2001 to weld